

ID 70304

02, 2011 2:37:52 PM

D3214-1

Req ID:

Item Name: Placard

Start Date: 6/8/2011

Start Qty: 10.00

Accept



Setup Start



Stop



Required Date: 6/17/2011

Req'd Qty: 10.00



Cust Item ID:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3214

Rev B

100



SHEAR

Shear

Shear

Memo

0.00

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

120



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70304

Thursday, June 02, 2011 2:37:52 PM



Page 2

Item ID: D3214-1

Accept



Setup Start



Revision ID:

Item Name: Placard

Stop



Start Date: 6/8/2011 Start Qty: 10.00



Required Date: 6/17/2011 Req'd Qty: 10.00



Reference:

Cust Item ID:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

14-X Ø M-F u/06/09

Memo 200 0.00
 START TIME: 3200P FINISH TIME: 2:30 OVEN TEMPERATURE:

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

14 BL 11-6-9

150



Small Fab

Small Fab

FAB

Small Fab

Memo

0.00

Engrave text as per Folio FA394 and Dwg D3214

0.00

mk 11/07/05

14 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 70304

Thursday, June 02, 2011 2:37:52 PM



Page 3

Item ID: D3214-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard

Start Date: 6/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

ark 11/07/05

14 - 8

180



Packaging

Packaging

Identify as per dwg & Stock Location

202

0.00

0.00

11/7/08

(14)

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/7/08
MF
11-07-06

Placard

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 2:37:49 PM

Page 1

Work Order ID: 70304



Parent Item: D3214-1



Parent Item Name: Placard

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A104.04.15 (New issue) KJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLMU

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		110	sf	257.0000	0.0743	0.782105			

6061-T6 .080 Sheet

Location	Loc Qty	Loc Code
MAT021	257	
116268	33.5	
117285	223.5	

118700

1.0 f 86/11/06/07

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>FF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>Pf</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE PLACARD	SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

06.06.20 *FF***D3214-1**NOTES

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70304
Description: PLACATE D	Part Number:	D3214-1
Inspection Dwg: 3214 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	11/06/07	Date:	11/7/07	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	